



Dart Aerospace Ltd.
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D3914-041
Job Sheet 168955-A



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/27/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/4/18	1/4/18	0.00	0.00	Start Up Large Fab-2		18-01-19
100	Large Fab	1 pcs	1/4/18	1/4/18	0.00	6.67	Large Fab 1		18-01-19
110	QC	1 pcs	1/4/18	1/4/18	0.00	0.00	QC9		CPC
120	QC	1 pcs	1/4/18	1/4/18	0.00	0.00	QC5		CPC
130	Powdercoat	1 pcs	1/4/18	1/4/18	0.00	0.40	Powdercoat4		18-01-31
135	QC	1 pcs	1/4/18	1/4/18	0.00	0.00	QC3		18-02-01
140	HandFinish	1 pcs	1/5/18	1/5/18	0.00	0.80	HandFinish3		18-02-01
150	QC	1 pcs	1/5/18	1/5/18	0.00	0.00	QC3		18-02-01
160	Packaging	1 pcs	1/5/18	1/5/18	0.00	0.00	Packaging3		18-02-01
170	QC21-SA	1 Ea	1/5/18	1/5/18	0.00	0.00	QC21		18-02-01

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M 135418 START: 3:20 O.V.T: 3:20 FINISH: 3:50 wingwalk M138711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581	2	77	0	0
	D3914-1	2	16	0	0
	D3914-7	2	24	0	0
	D4016-3	3	51	0	0
	D4018-5	9	63	0	0
	D4020-5	1	2	0	0
	D4021-3	1	15	0	0
	D4035-043	2	10	0	0
	D2728-3	1	0	0	0
	D2728-3	1	0	0	0
140-HandFinish					

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

DISPOSITION

Rework ☐

Scrap ☐

Use-as-is ☐

Approved ☐

Skid-tube ☐

Machining ☐

Thermoforming ☐

Large Fab ☐

Cross tube ☐

Small Fab ☐

Finishing ☐

Composite ☐

Water Jet ☐

Prod. Eng. Coord. ☐

Rec/Store/Packaging ☐

Supplier ☐

Engineering ☐

Quality ☐

Other ☐

QTY Effective : _____

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

FAULT CATEGORY

☐ Temperature/Cure

☐ Set-up

☐ BOM/Route

☐ Broken/Damage/Defect

☐ Inspection Incomplete/Unqualified

☐ Contamination

☐ Countersink

☐ Cut Too Short

☐ Instructions Incomplete/Unclear

☐ Drill Holes

☐ Power Loss/Surge

☐ Folio/Program

☐ Grain

☐ Weld

☐ Wrong Stock Pulled

☐ Out of Sequence

☐ Off-set

☐ Mislabeled

☐ Fit/Function

☐ Misaligned/off center

☐ Positioned Wrong

☐ Outside Dimensions

☐ Over/Under tolerance

☐ Part Incorrect

☐ Part Lost/Missing

☐ Part Moved

☐ Drawing

☐ Finish

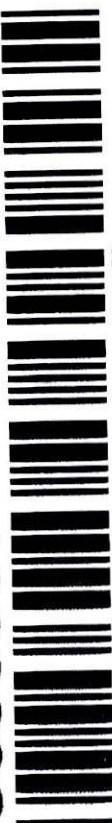
☐ Misread

☐ Turning Sequence

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DART
AEROSPACE
S033967



Long Basket Lid Assembly (350)

PART NO: D3914-041

Original Serial #: S033967

Revision:

Operation: Start up Operation 01/19/18

Change No:

Job No: 168160

Past expiry Date

Misidentified

Manufacturing Process

Past Due

OTHER :